

Date: Wednesday, 24/09/2008 1:28:47 PM
 User: Jean-Luc Menard

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BACK LEG |
| Job Number : 42240 | |
| Estimate Number : 13378 | |
| P.O. Number : | Part Number : D37721 |
| This Issue : 24/09/2008 S.O. No. : | Drawing Number : D3772 REVA |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 1/1 Type : MACHINED PARTS | Drawing Revision : A |
| Previous Run : 42240 | Material : |
| Written By : <i>[Signature]</i> 08-09-24 | Due Date : 01/10/2008 Qty: 14 Um: Each |
| Checked & Approved By : | |
| Comment : Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC Est Rev:B 08-09-24 Now on Haas JLM Verified By:EC | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------------|---------------------------|
| 1.0 | M304TR1250W125 | 304 RD Tube 1.250 x .125w |
|-----|----------------|---------------------------|



Comment: Qty.: 2.7565 f(s)/Unit Total : 38.5904 f(s)

304 RD Tube 1.250 x .125w

BATCH: *08/11/09/24*

SP 08/09/24

(12)

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW (chop saw)

Cut blank 31.500" long

SP 08/09/25

(12)

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA787 Rev. *AA* & Dwg D3772 Rev. *J*

N.A

08/09/27

(12)

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A

08/09/27

(12)

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



♦ Comment: SECOND CHECK

SP 08/09/29

(12)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK LEG

Job Number: 42240

Part Number: D37721

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to lenght as per dwg D3772

2- deburr

SAO 08/10/08 (12)

3-bend tube as per dwg D3772

FF 08/10/09

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

So 08/10/16 (12x)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 299

8/10/16

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



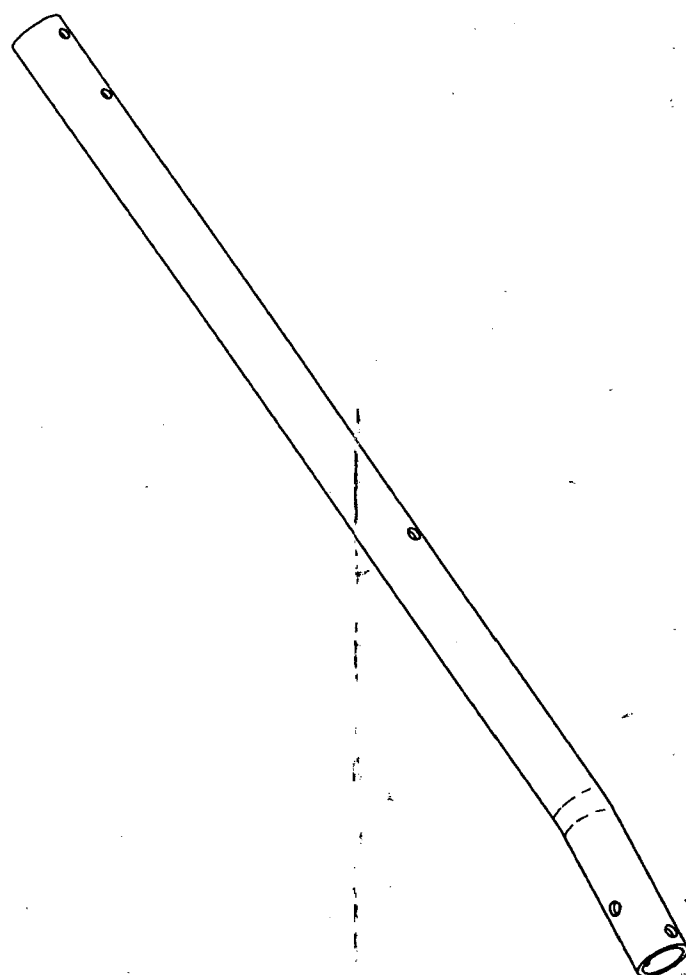
Comment: FINAL INSPECTION/W/O RELEASE

08/10/16 JF

Job Completion



MF 08-10-16



D3772-1 BACK LEG

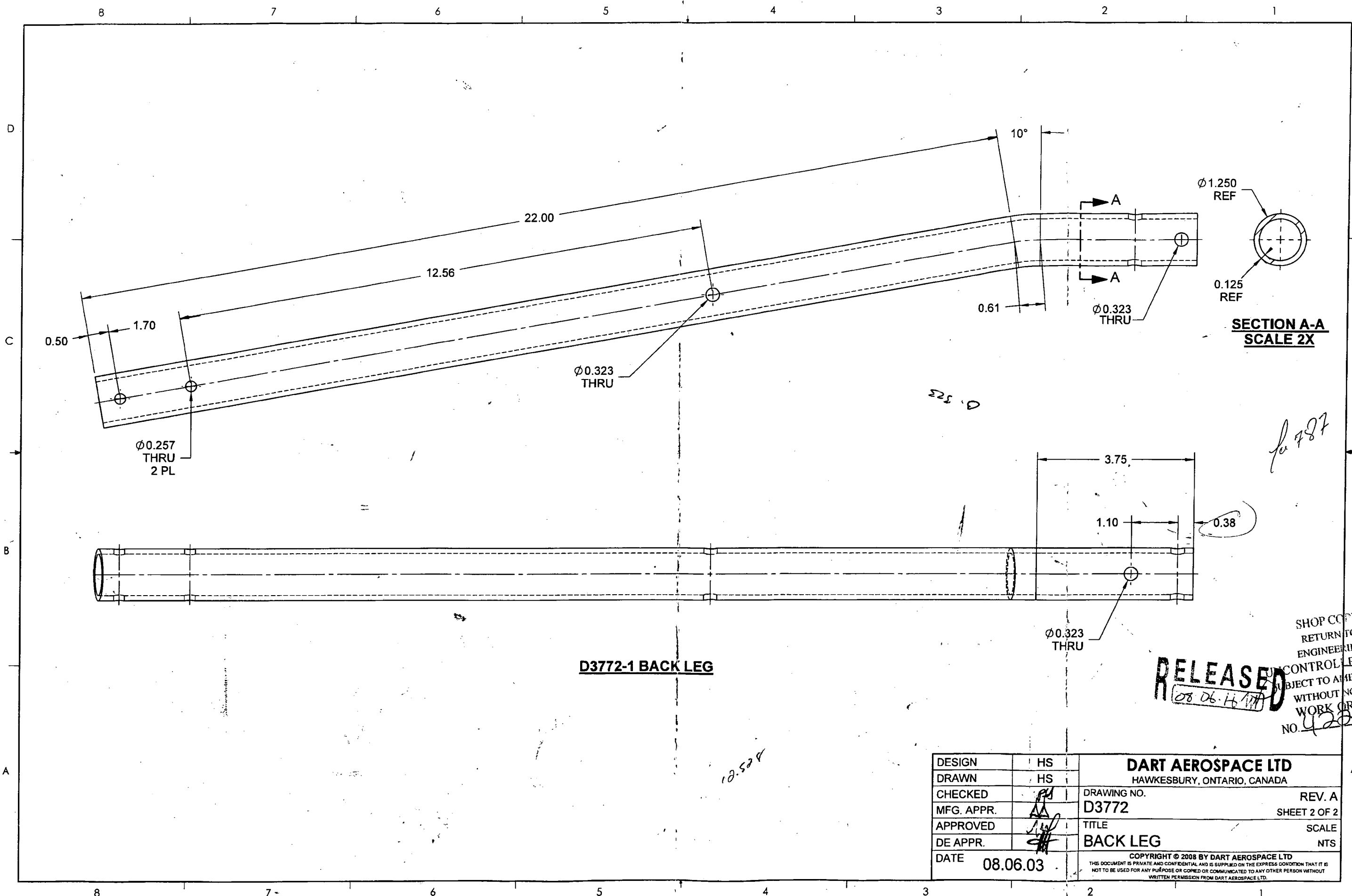
NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.26 lbs

| | | | |
|------------|--------------------|--|--------------|
| A | NEW ISSUE | HS | 08.06.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | HS | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D3772 | SHEET 1 OF 2 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | BACK LEG | NTS |
| DATE | 08.06.03 | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **42240**

RELEASED
08-06-13/11/14



D3772-1 BACK LEG

RELEASED
08-06-16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42860

| | | | |
|------------|----------|--|--------------|
| DESIGN | HS | DART AEROSPACE LTD | |
| DRAWN | HS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PS | DRAWING NO. | REV. A |
| MFG. APPR. | AA | D3772 | SHEET 2 OF 2 |
| APPROVED | TH | TITLE | SCALE |
| DE APPR. | TH | BACK LEG | NTS |
| DATE | 08.06.03 | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

